

Work Order ID 82647

April-04-12 10:53:36 AM

82647

May 14th Page 1

Item ID: D4273-042 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Basket Base Assembly, RH
 Start Date: 04/04/2012 Start Qty: 1.00 ***1*** Cust Item ID:
 Required Date: 30/04/2012 Req'd Qty: 1.00 ***1*** Customer:
 Reference:

Approvals: Process Plan: MLJ Date: 12/04/04 Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D4273	D								
D4279	B								
100	Weld per dwg A/R S.S. rod Batch: <u>118366</u>	0.00							
100	Large Fab								
Large Fab	Memo	0.00							
	1- assemble ribs and handle plates (DO NOT WELD HANDLE IN SECTION N-N ON PAGE 7 DWG D4273, NEED TO WELDED AFTHET MESH IS INSTALL) weld as per dwg D4273 using DT9610A								
	visual inspect before welding mesh								
	2- Cut D4279-1 (MADE ON THIS W/O) base mesh and tack weld all mesh on basket as per dwg D4273 and trim mesh to fit if necessary and trim to clear fasteners holes on the ends (D4279-5/-9)								
	3- weld hinge (3) and Mounting brackets as per dwg D3913								
	take lid to locate hinge and bracket								
110	QC9- Inspect visual per QSI004- Fusion Welds	0.00							
110									
QC	Memo	0.00							
Quality Control									

1x 12.05.23

12.05.23

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 82647

April-04-12 10:53:36 AM

82647

Page 2

Item ID: D4273-042 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Basket Base Assembly, RH
 Start Date: 04/04/2012 Start Qty: 1.00 ***1*** Cust Item ID:
 Required Date: 30/04/2012 Req'd Qty: 1.00 ***1*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120 *120* QC Quality Control	QC6- Inspect dimensions to drawing Memo	0.00 0.00		5/2/01/23					
125 *125* HandFinish Hand Finishing	Pressure Wash per QSI005 4.3 Memo	0.00 0.00							2/5 12-5-24

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 82647

April-04-12 10:53:36 AM

82647

Page 3

Item ID: D4273-042 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Basket Base Assembly, RH
 Start Date: 04/04/2012 Start Qty: 1.00 ***1*** Cust Item ID:
 Required Date: 30/04/2012 Req'd Qty: 1.00 ***1*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 *130* Powdercoat Powder Coating	White Gloss(Ref:4.3.5.2) per QSI005 4.3-Steel Memo 1- Plug holes and mask only interior of hinge (3) prior to powder coat 1ST COAT: <u>2-30</u> START TIME: <u>400</u> OVEN TEMPERATURE: <u>0 F</u> FINISH TIME: <u>3:00</u> ***** 2nd coat if necessary ***** 2ND COAT: START TIME: _____ OVEN TEMPERATURE: _____ FINISH TIME: _____	0.00 0.00				<u>IX</u>	<u>Ø</u>		<u>M-F</u> <u>12/05/28</u>
140 *140* QC Quality Control	QC3- Inspect Part Finish Memo	0.00 0.00				<u>1</u>	<u>Ø</u>		<u>12/05/28</u>

M1 21134

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Page 4

MF
12-05-20

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

April-04-12 10:53:39 AM

Page 1

Work Order ID: 82647

82647

Parent Item: D4273-042

D4273-042

Parent Item Name: Basket Base Assembly, RH

Start Date: 04/04/2012

Required Date: 30/04/2012

Start Qty: 1.00

Required Qty: 1.00

Comments:

IPP Rev:A 10.11.16 new issue DD verf:EC

IPP Rev:B

11.01.20 AS PER DWG REV.C DD verf:EC

IPP Rev:C 11.03.03

AS PER DWG REV.D DD verf:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

M304EX0.75-16F

Purchased

No

100

sf

816.3309

26.195

26.195

M304FX0 75-16F

Expanded Metal Flat SS

**

M-121738 26.195

Ar 12.05.17

Location

Loc Qty

Loc Code

WA

0.0001156

119180

0.0001156

WA035

816.3307641

117197

102.9036

117896

29.49258

118153

76.8473

118955

82.17

119180

53.6958107

119729

28.1132686

120153

2.97557478

120917

210.99263

121082

229.14

D3913-1

Manufactured

No

100

Each

9.0000

1

1

D3913-1

Rib

**

SAD 12.05.16

Location

Loc Qty

Loc Code

WA

3

74145

0

80790

3

WA006

6

81437

6

B83226

0

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

April-04-12 10:53:39 AM

Page 2

Work Order ID: 82647

82647

Parent Item: D4273-042

D4273-042

Parent Item Name: Basket Base Assembly, RH

Start Date: 04/04/2012

Required Date: 30/04/2012

Start Qty: 1.00

Required Qty: 1.00

D3913-3

Manufactured No

100

Each

11.0000

1

1

D3913-3

Rib

**

SAD 12-05-16

Location

Loc Qty

Loc Code

WA

6

69160

0

74144

0

81443

6

WA006

5

69160

1

78287

1

81714

3

D3913-9

Manufactured No

100

Each

12.0000

1

1

D3913-9

Hinge Rib

**

SAD 12-05-16

Location

Loc Qty

Loc Code

WA

10

81200

10

WA006

2

70138

1

80791

1

D3916-5

Manufactured No

100

Each

7.0000

3

3

D3916-5

Light Rib

**

SAD 12-05-16

Location

Loc Qty

Loc Code

WA

7

81434

7

B 82920 ①

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

April-04-12 10:53:40 AM

Page 3

Work Order ID: 82647

82647

Parent Item: D4273-042

D4273-042

Parent Item Name: Basket Base Assembly, RH

Start Date: 04/04/2012

Required Date: 30/04/2012

Start Qty: 1.00

Required Qty: 1.00

D4017-7

Manufactured No

100

Each

9.0000

1

1

D4017-7

Rib

**

SAD 12-05-16

Location

Loc Qty

Loc Code

WA005

9

69730

1

81176

8

D4277-3

Manufactured No

100

Each

0.0000

1

D4277-3

Rib

B82969

①

B80748 **

SAD 12-05-16

D4277-5

Manufactured No

100

Each

0.0000

2

2

D4277-5

Rib

B84124 **

SAD 12-05-16

D4277-9

Manufactured No

100

Each

0.0000

1

1

D4277-9

Rib

B80749 **

SAD 12-05-16

D4277-19

Manufactured No

100

Each

0.0000

1

1

D4277-19

Rib

B80747 **

SAD 12-05-16

D4278-041

Manufactured No

100

Each

1.0000

1

1

D4278-041

Upper Rib Assembly-Hoop

**

SAD 12-05-16

Location

Loc Qty

Loc Code

WA

1

80603

1

D4278-045

Manufactured No

100

Each

0.0000

2

2

D4278-045

Rib Assembly, Fwd Cham

**

①
B80750 → ②
SAD 12-05-16

April-04-12 10:53:40 AM

Shop Packet Print

Page 3

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

April-04-12 10:53:40 AM

Page 4

Work Order ID: 82647

82647

Parent Item: D4273-042

D4273-042

Parent Item Name: Basket Base Assembly, RH

Start Date: 04/04/2012

Required Date: 30/04/2012

Start Qty: 1.00

Required Qty: 1.00

D4278-047

Manufactured No

100

Each

2.0000

1

1

D4278-047

Upper Rib Assembly-Straight

**

SAD 12-05-16

Location

Loc Qty

Loc Code

WA

2

80600

2

D4306-1

Manufactured No

100

Each

1.0000

1

1

D4306-1

Rib

**

SAD 12-05-16

Location

Loc Qty

Loc Code

WA006

1

74278

1

D4306-044

Manufactured No

100

Each

0.0000

1

1

D4306-044

Rib Assembly, RH

D4306-045

Manufactured No

100

Each

4.0000

1

1

D4306-045

Rib Assembly

**

SAD 12-05-16

Location

Loc Qty

Loc Code

WA006

4

72323

4

D2581

Manufactured No

100

Each

27.0000

2

2

D2581

Mounting Bracket

**

SAD 12-05-16

Location

Loc Qty

Loc Code

WA005

27

69739

1

70766

2

77045

1

77523

1

81253

22

B8007

2

April-04-12 10:53:40 AM

Shop Packet Print

Page 4

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

April-04-12 10:53:40 AM

Page 5

Work Order ID: 82647

Parent Item: D4273-042

Parent Item Name: Basket Base Assembly, RH

82647

D4273-042

Start Date: 04/04/2012

Required Date: 30/04/2012

Start Qty: 1.00

Required Qty: 1.00

D3913-15

Manufactured No

100

Each

10.0000

1

1

D3913-15

Wide Handle Plate

**

SAN 12-05-12

Location

Loc Qty

Loc Code

WA

6

81440

6

WA005

4

80778

4

D4016-1

Manufactured No

100

Each

18.0000

3

3

D4016-1

Hinge Half, Base

**

SAN 12-05-16

Location

Loc Qty

Loc Code

WA

15

66418

0

81702

15

WA005

3

79413

3

D4021-1

Manufactured No

100

Each

27.0000

3

3

D4021-1

Handle Plate

**

SAN 12-05-16

Location

Loc Qty

Loc Code

WA005

27

80826

22

81433

5

D4279-3

Manufactured No

100

Each

0.0000

1

1

D4279-3

Mesh, Chamfer

**

B82632 → ① Pl 12-05-17

April-04-12 10:53:40 AM

Shop Packet Print

Page 5

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

April-04-12 10:53:40 AM

Page 6

Work Order ID: 82647

82647

Parent Item: D4273-042

D4273-042

Parent Item Name: Basket Base Assembly, RH

Start Date: 04/04/2012

Required Date: 30/04/2012

Start Qty: 1.00

Required Qty: 1.00

D4279-5

Manufactured No

100

Each

2.0000

1

1

D4279-5

End Mesh, Basket

**

B84347 ① Ae 12.05.17

Location

Loc Qty

Loc Code

WA035

2

73270

2

D4279-7

Manufactured No

100

Each

0.0000

2

2

D4279-7

End Mesh, Basket

**

B84128 ② Ae 12.05.17

D4279-9

Manufactured No

100

Each

3.0000

1

1

D4279-9

End Mesh, Basket

**

Ae 12.05.17

Location

Loc Qty

Loc Code

WA035

3

73265

3

D4279-11

Manufactured No

100

Each

0.0000

1

1

D4279-11

Mesh, Base

**

B84350 → ① Pl 12.05.17

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

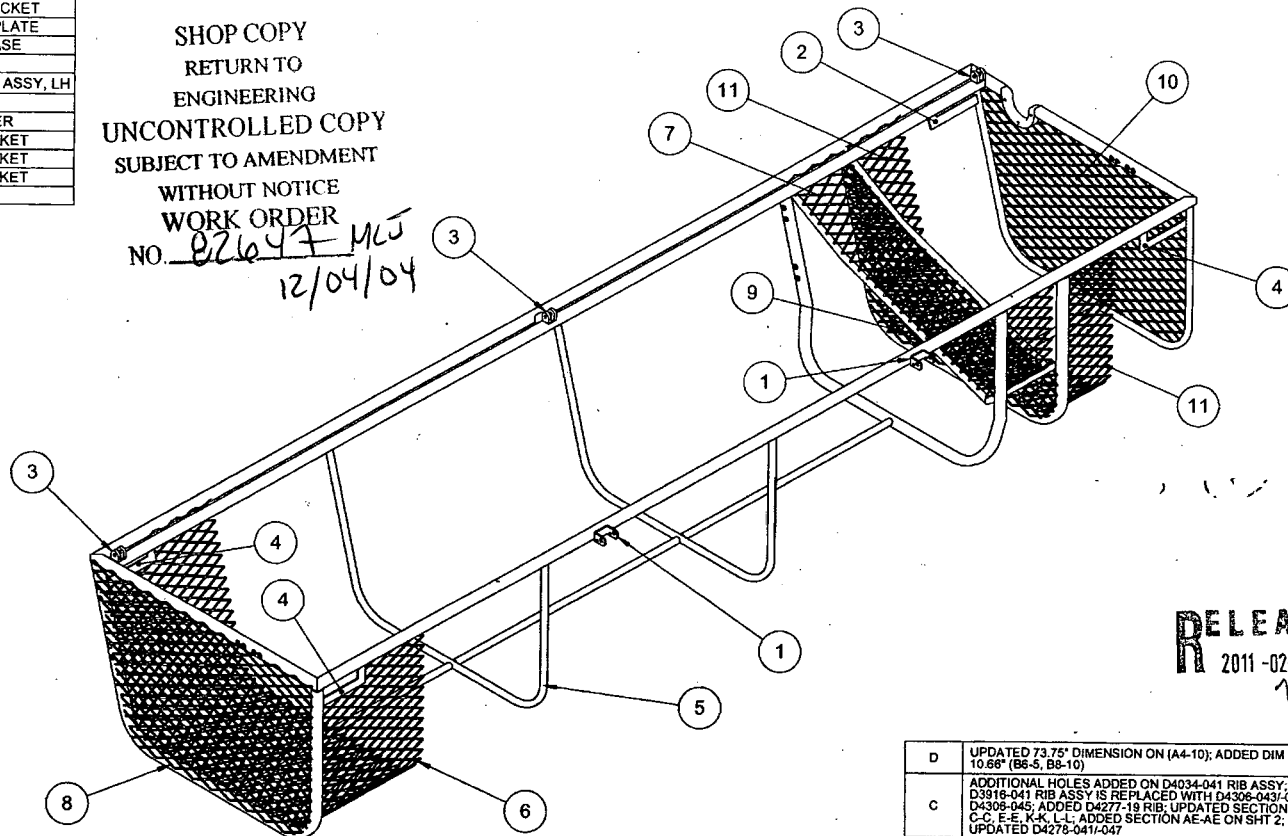
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

ITEM	QTY	PART NUMBER	DESCRIPTION
	X	D4273-041	BASKET BASE ASSY, LH
1	2	D2581	MOUNTING BRACKET
2	1	D3913-15	WIDE HANDLE PLATE
3	3	D4016-1	HINGE HALF, BASE
4	3	D4021-1	HANDLE PLATE
5	1	D4273-141	BASKET FRAME ASSY, LH
6	1	D4279-1	MESH - BASE
7	1	D4279-3	MESH - CHAMFER
8	1	D4279-5	END MESH, BASKET
9	2	D4279-7	END MESH, BASKET
10	1	D4279-9	END MESH, BASKET
11	1	D4279-11	MESH - BASE

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 82647 MJS
12/04/04



D4273-041 BASKET BASE ASSY, LH
(MESH SHOWN LOCALLY FOR CLARITY)

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: POWDER COAT WHITE (4.3.5.2) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 45 lbs APPROX
- 8) WELD PER DART QSI 004
- 9) MASK HOLES PRIOR TO POWDER COAT
- 10) TRIM AS NECESSARY TO CLEAR FASTENERS/STRUCTURE.

RELEASED
R 2011-02-24

D	UPDATED 73.75" DIMENSION ON (A4-10); ADDED DIM 10.88" (B6-5, B8-10)	SC	11.02.09
C	ADDITIONAL HOLES ADDED ON D4034-041 RIB ASSY; D3916-041 RIB ASSY IS REPLACED WITH D4306-043-044 & D4306-045; ADDED D4277-18 RIB; UPDATED SECTION B-B, C-C, E-E, K-K, L-L; ADDED SECTION AE-AE ON SHT 2; UPDATED D4278-041-047	SC	10.12.23
B	REDESIGN: ADD (1) D4021-1, (1) D4279-7, (1) D4279-11 (D6-1 D6-9); RMV D4277-17, D4278-043 (SHT 4.9); ADD (1) D3916-1, (2) D4277-5, (1) D4277-9, (1) D4306-1 (D6-4, D6-9), RMV (1) D4277-3 (D6-4, D6-9); 24.25 WAS 20.25 (A5-5, A5-10)	CP	10.11.30
A	NEW ISSUE	SC	10.11.25
REV.	DESCRIPTION	BY	DATE
DESIGN	JPH	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	SC		
CHECKED		DRAWING NO.	REV. D
MFG. APPR.		D4273	SHEET 1 OF 10
APPROVED		TITLE	SCALE
DE APPR.		BASKET BASE ASSY	NTS
DATE	11.02.09	COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

DETAIL D (D7-2)
D4279-1 MESH - BASE
TACK WELD MESH AT EVERY AVAIL LOCATION

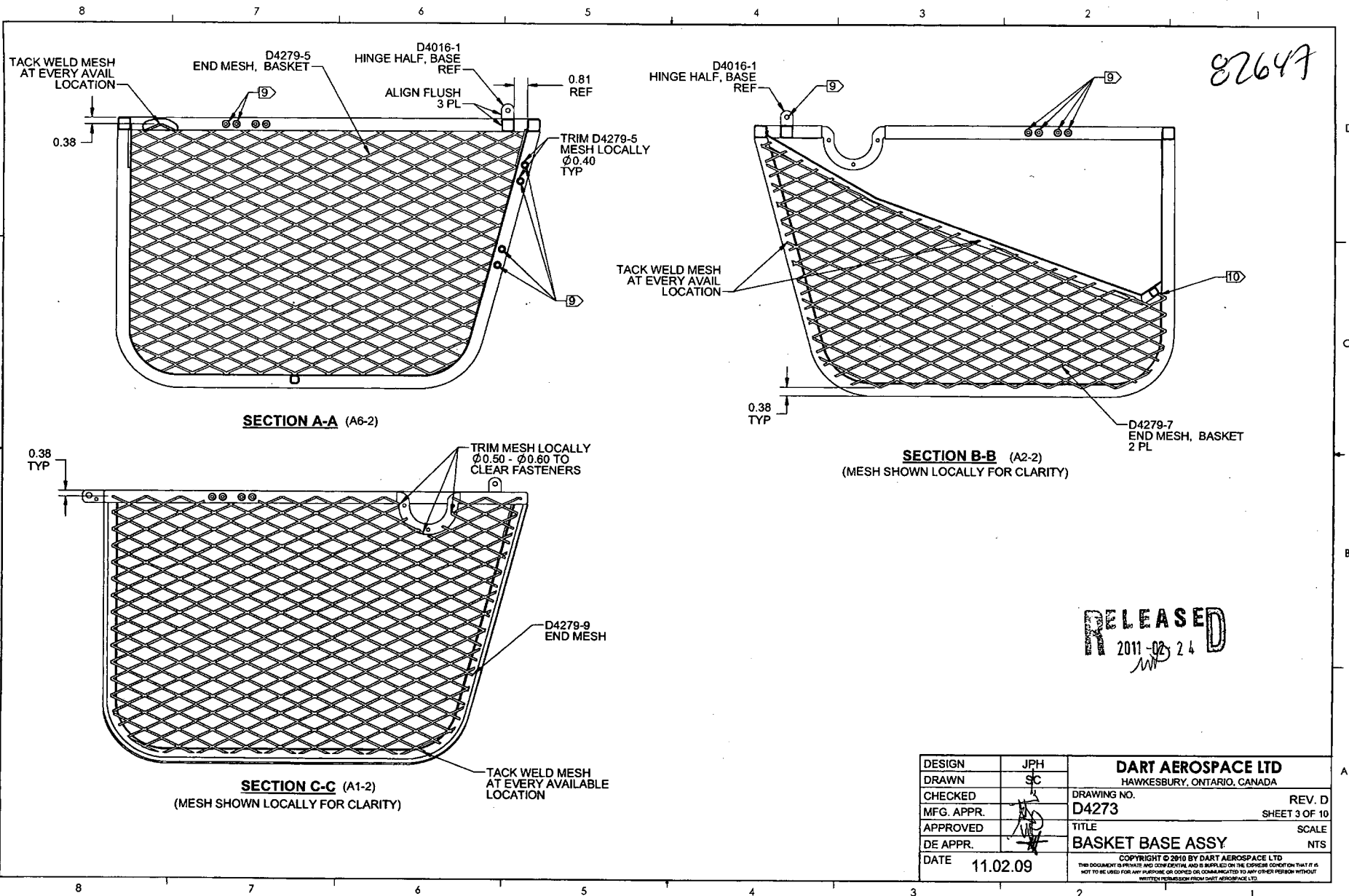
SECTION AE-AE (C7-2)
3 PLACES
D4279-1 MESH REF 10
D4021-1 HANDLE PLATE OR D3913-15 WIDE HANDLE PLATE REF
TACK WELD MESH AT EVERY AVAIL LOCATION

SECTION E-E (D6-2)
1 PLACE
D4279-1 MESH REF 10
D4021-1 HANDLE PLATE REF
TACK WELD MESH AT EVERY AVAIL LOCATION

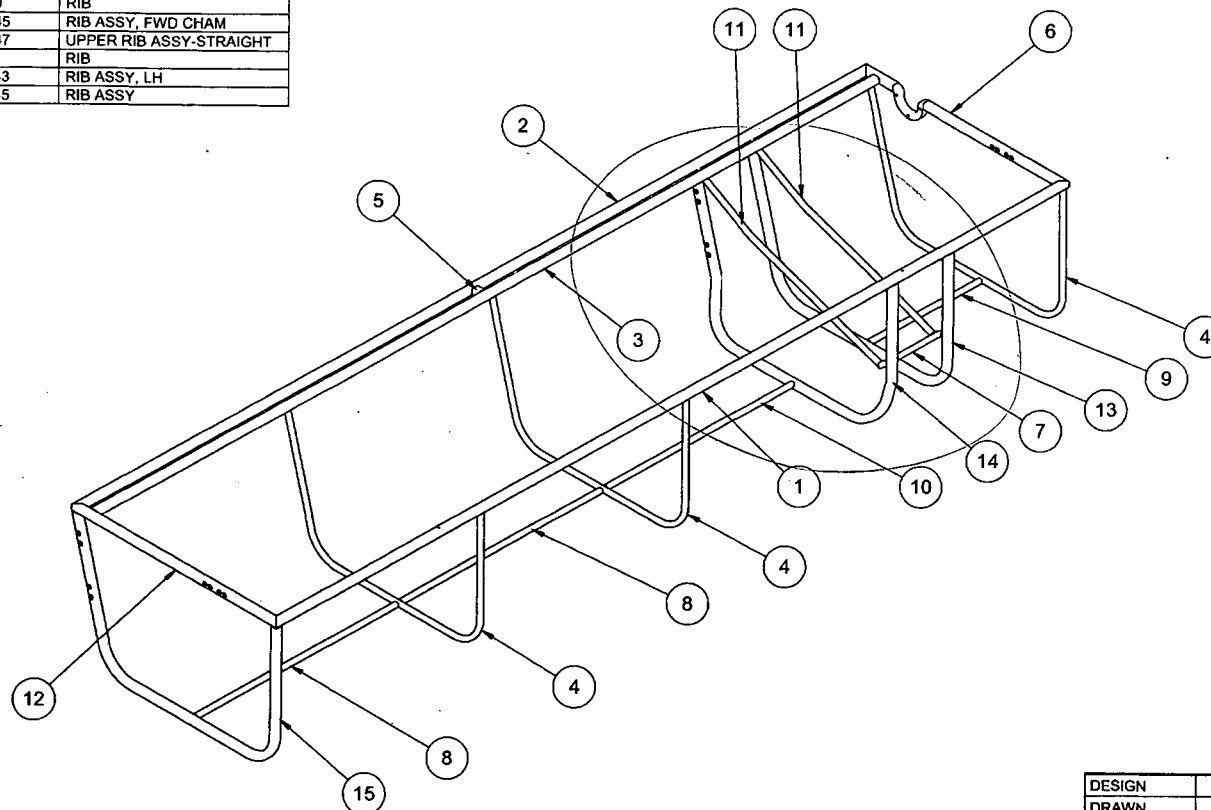
D4273-041 BASKET BASE ASSY, LH
(MESH SHOWN LOCALLY FOR CLARITY)

RELEASED
2011-02-24

DESIGN	JFH	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA DRAWING NO. D4273 TITLE BASKET BASE ASSY COPYRIGHT © 2010 BY DART AEROSPACE LTD <small>THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>
DRAWN	SC	
CHECKED	12	
MFG. APPR.	[Signature]	
APPROVED	[Signature]	
DE APPR.	[Signature]	REV. D SHEET 2 OF 10 SCALE NTS
DATE	11.02.09	



ITEM	QTY	PART NUMBER	DESCRIPTION
	X	D4273-141	BASKET FRAME ASSY, LH
1	1	D3913-1	RIB
2	1	D3913-3	RIB
3	1	D3913-9	HINGE RIB
4	3	D3916-5	LIGHT RIB
5	1	D4017-7	RIB
6	1	D4034-041	AFT UPPER RIB ASSY
7	1	D4277-3	RIB
8	2	D4277-5	RIB
9	1	D4277-9	RIB
10	1	D4277-19	RIB
11	2	D4278-045	RIB ASSY, FWD CHAM
12	1	D4278-047	UPPER RIB ASSY-STRAIGHT
13	1	D4306-1	RIB
14	1	D4306-043	RIB ASSY, LH
15	1	D4306-045	RIB ASSY

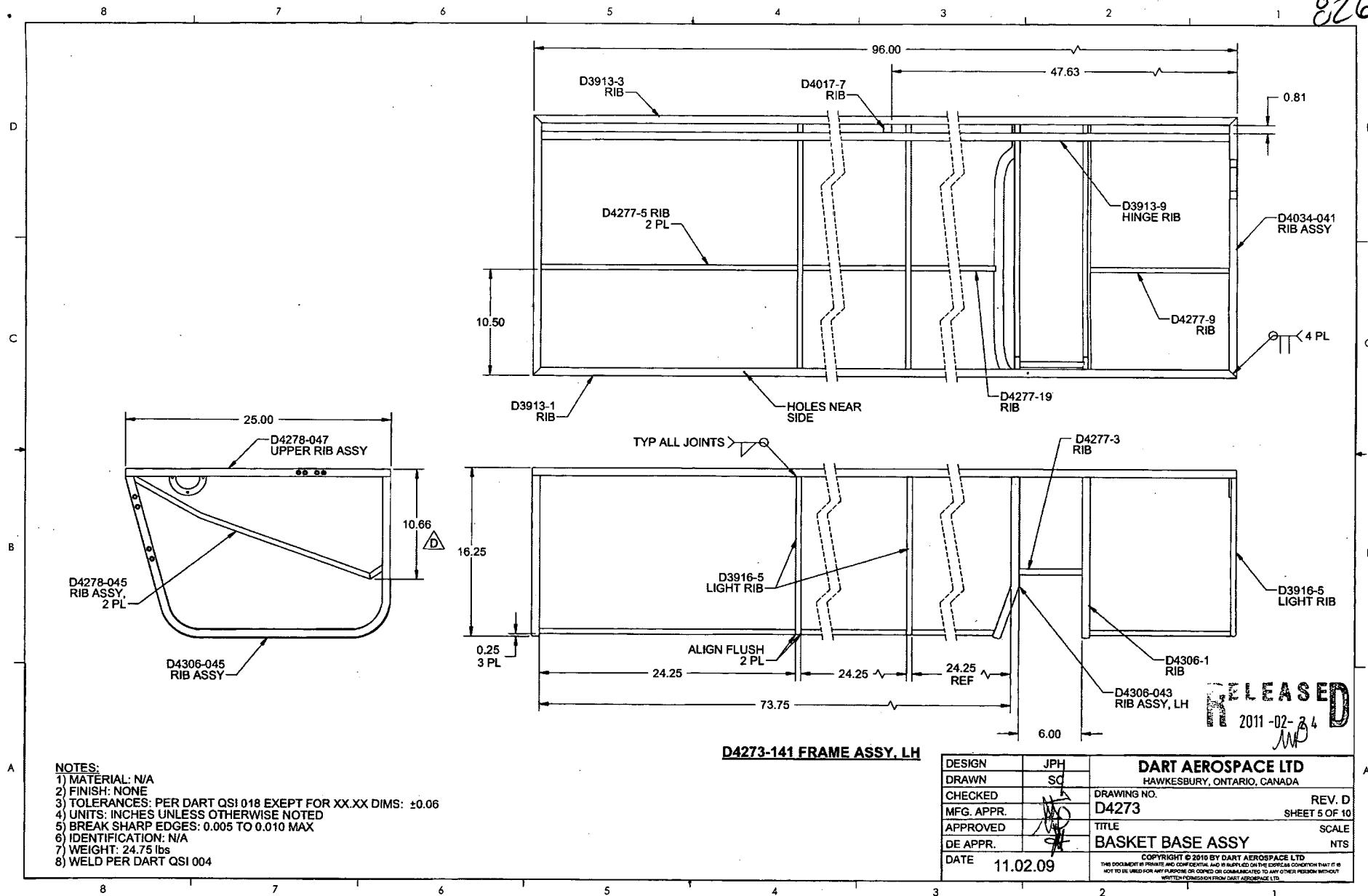


D4273-141 FRAME ASSY, LH

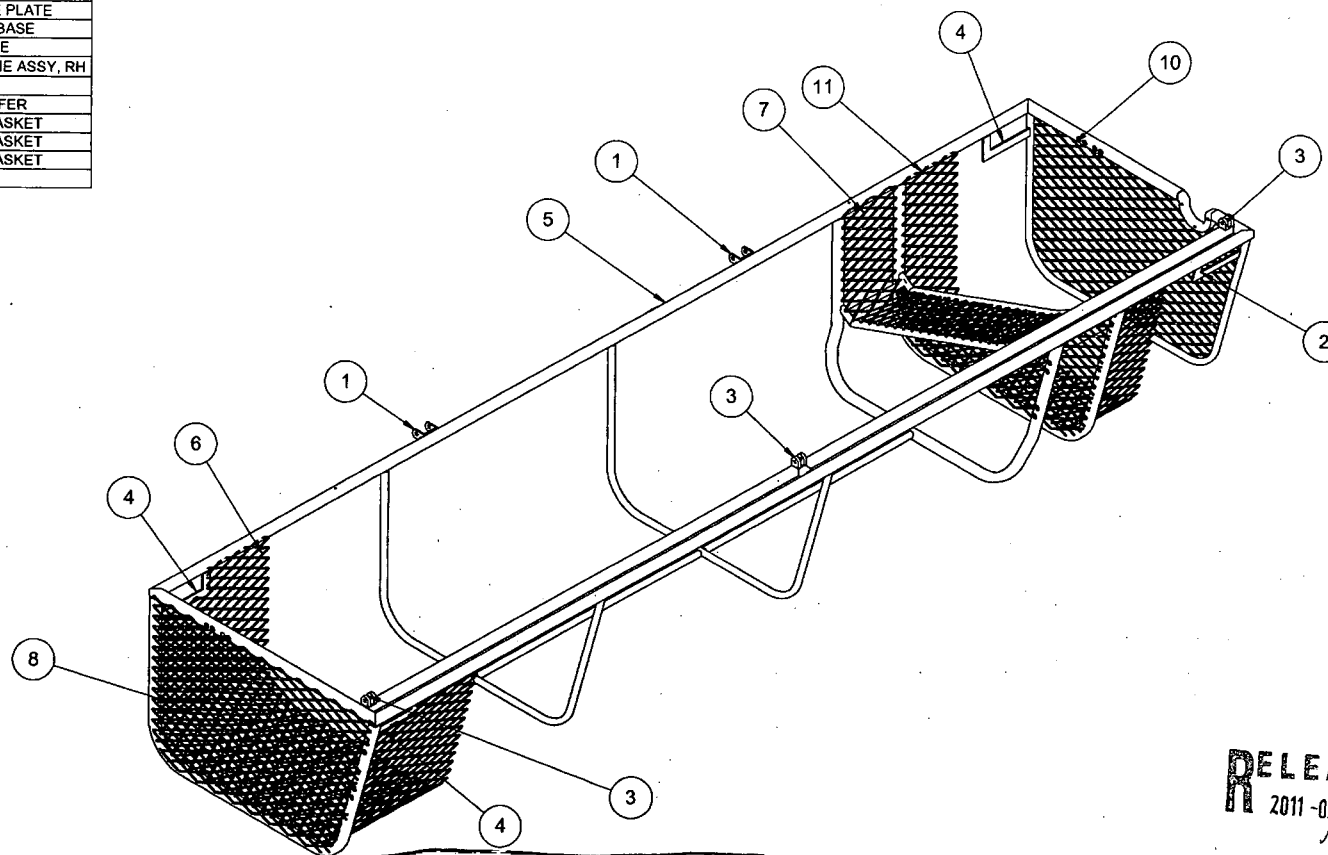
RELEASED
2011-02-21
MD

DESIGN	JPH	DART AEROSPACE LTD	
DRAWN	SC	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. D
MFG. APPR.		D4273	SHEET 4 OF 10
APPROVED		TITLE	SCALE
DE APPR.		BASKET BASE ASSY	NTS
DATE	11.02.09	<small>COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

82647



ITEM	QTY -042	PART NUMBER	DESCRIPTION
	X	D4273-042	BASKET BASE ASSY, RH
1	2	D2581	MOUNTING BRACKET
2	1	D3913-15	WIDE HANDLE PLATE
3	3	D4016-1	HINGE HALF, BASE
4	3	D4021-1	HANDLE PLATE
5	1	D4273-142	BASKET FRAME ASSY, RH
6	1	D4279-1	MESH - BASE
7	1	D4279-3	MESH - CHAMFER
8	1	D4279-5	END MESH, BASKET
9	2	D4279-7	END MESH, BASKET
10	1	D4279-9	END MESH, BASKET
11	1	D4279-11	MESH - BASE



D4273-042 BASKET BASE ASSY, RH
(MESH SHOWN LOCALLY FOR CLARITY)

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: POWDER COAT WHITE (4.3.5.2) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 45 lbs APPROX
- 8) WELD PER DART QSI 004
- 9) MASK HOLES PRIOR TO POWDER COAT
- 10) TRIM AS NECESSARY TO CLEAR FASTENERS/STRUCTURE.

RELEASED
2011-02-24

DESIGN	JPH	DART AEROSPACE LTD	
DRAWN	SC	HAWKESBURY, ONTARIO, CANADA	
CHECKED	SC	DRAWING NO.	REV. D
MFG. APPR.	SC	D4273	SHEET 6 OF 10
APPROVED	SC	TITLE	SCALE
DE APPR.	SC	BASKET BASE ASSY	NTS
DATE	11.02.09	<small>COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR REPRODUCED IN ANY FORM OR BY ANY MEANS WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

Technical drawing of a BASKET BASE ASSY, showing top, side, and section views with dimensions and part numbers.

Top View:

- Overall dimensions: 30.00, 34.50, 45.94, 45.94.
- Part numbers: D2581 MOUNTING BRACKET 2 PL, D4279-11 MESH-BASE, D4279-1 MESH-BASE, D4273-142 FRAME ASSY, RH, D4279-3 MESH-CHAMFER, D3913-15 WIDE HANDLE PLATE, D4016-1 HINGE HALF, BASE 3 PL.
- Section lines: AF-AF, N-N, J-J, K-K, L-L, C1-8, A8-8.
- Notes: TACK WELD MESH AT EVERY AVAILABLE LOCATION.

Side View:

- Overall dimensions: 0.75, 45.94, 45.94.
- Part numbers: D4021-1 HANDLE PLATE, D4016-1 HINGE HALF, BASE 3 PL.
- Section lines: J-J, K-K, L-L, C1-8, A8-8.

Section N-N (1 PLACE):

- Dimensions: 0.75, C7-7.
- Part numbers: D4021-1 HANDLE PLATE REF, D4279-1 MESH REF.
- Note: TACK WELD MESH AT EVERY AVAILABLE LOCATION.

Section AF-AF (3 PLACES):

- Dimensions: D7-7.
- Part numbers: D4021-1 HANDLE PLATE OR D3913-5 WIDE HANDLE PLATE REF, D4279-1 MESH REF.
- Note: TACK WELD MESH AT EVERY AVAILABLE LOCATION.

Section AF-AF (3 PLACES):

- Part number: D4273-042 BASKET BASE ASSY, RH (MESH SHOWN LOCALLY FOR CLARITY).

Table:

DESIGN	JPH	DATE
DRAWN	SC	11.02.09
CHECKED		
MFG. APPR.		
APPROVED		
DE APPR.		

Company Information:

DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

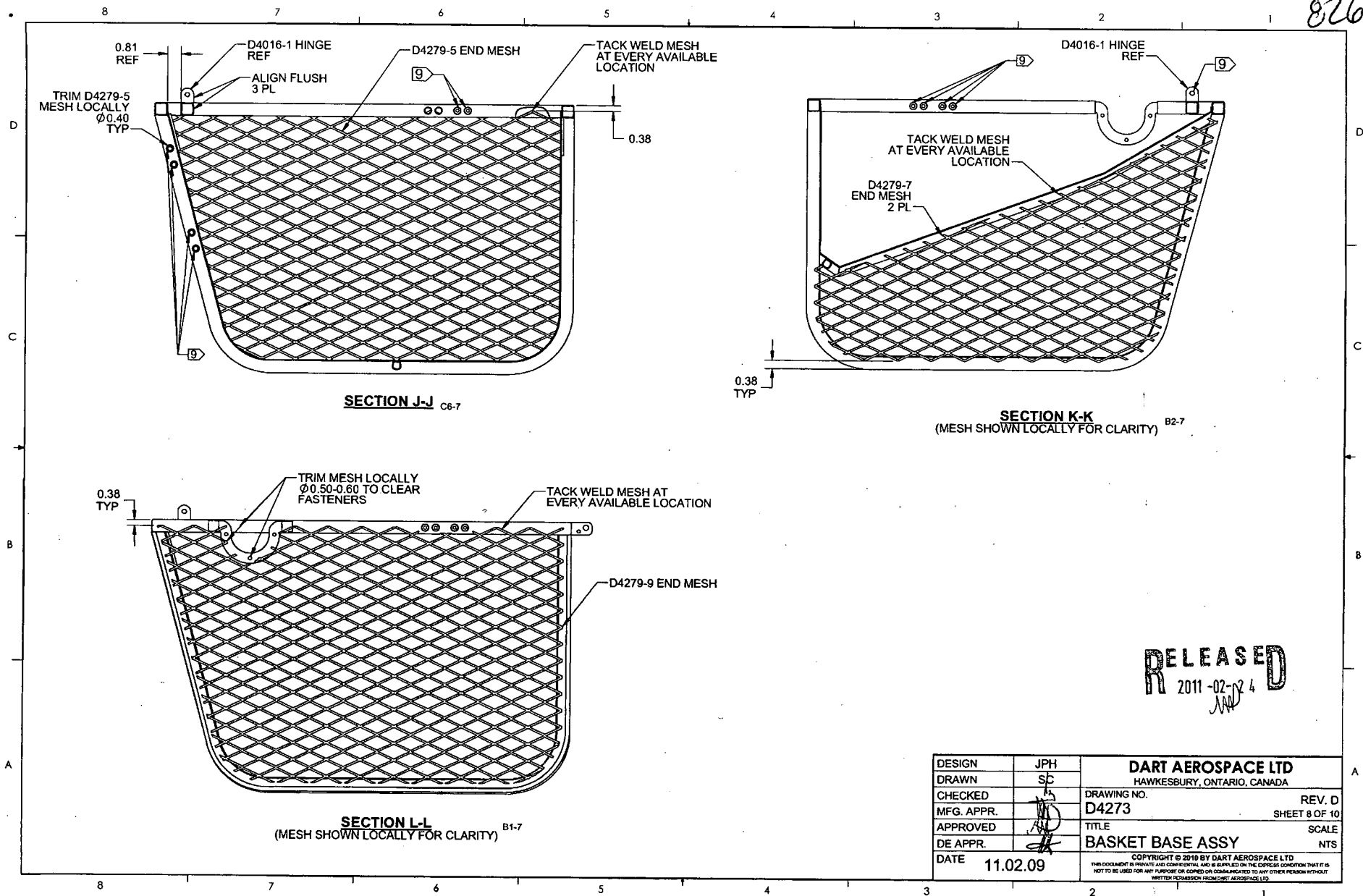
Drawing Information:

DRAWING NO. **D4273**
TITLE **BASKET BASE ASSY**
SCALE **NTS**

Revision: REV. D
SHEET 7 OF 10

Copyright: COPYRIGHT © 2010 BY DART AEROSPACE LTD
THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.

82647

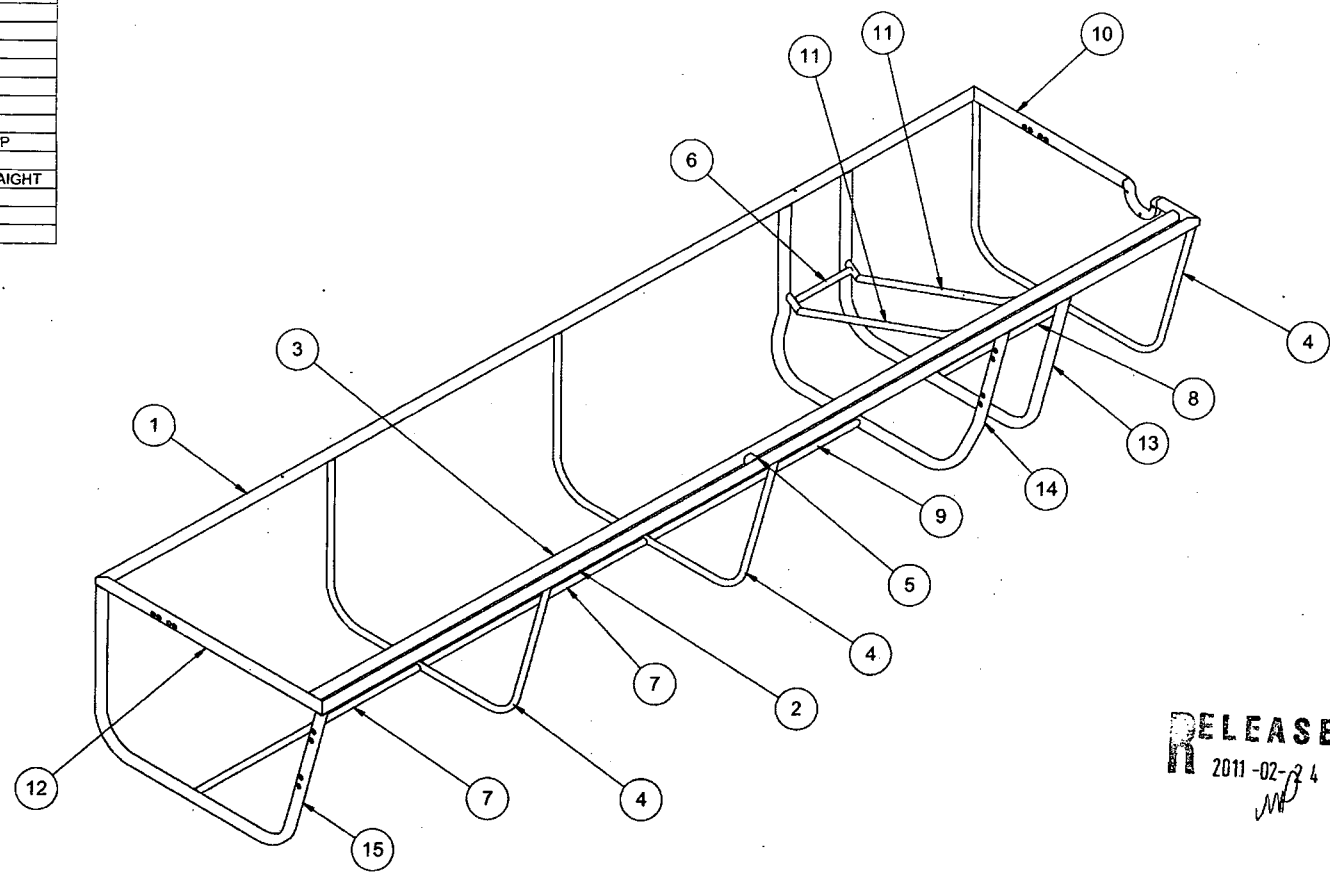


RELEASED
R 2011-02-24
JAW

DESIGN	JPH	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	SC		
CHECKED		DRAWING NO.	REV. D
MFG. APPR.		D4273	SHEET 8 OF 10
APPROVED		TITLE	SCALE
DE APPR.		BASKET BASE ASSY	NTS
DATE	11.02.09	COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

82647

ITEM	QTY	PART NUMBER	DESCRIPTION
	X	D4273-142	BASKET FRAME ASSY, RH
1	1	D3913-1	RIB
2	1	D3913-3	RIB
3	1	D3913-9	HINGE RIB
4	3	D3916-5	LIGHT RIB
5	1	D4017-7	RIB
6	1	D4277-3	RIB
7	2	D4277-5	RIB
8	1	D4277-9	RIB
9	1	D4277-19	RIB
10	1	D4278-041	UPPER RIB ASSY-HOOP
11	2	D4278-045	RIB ASSY, FWD CHAM
12	1	D4278-047	UPPER RIB ASSY-STRAIGHT
13	1	D4306-1	RIB
14	1	D4306-044	RIB ASSY, RH
15	1	D4306-045	RIB ASSY

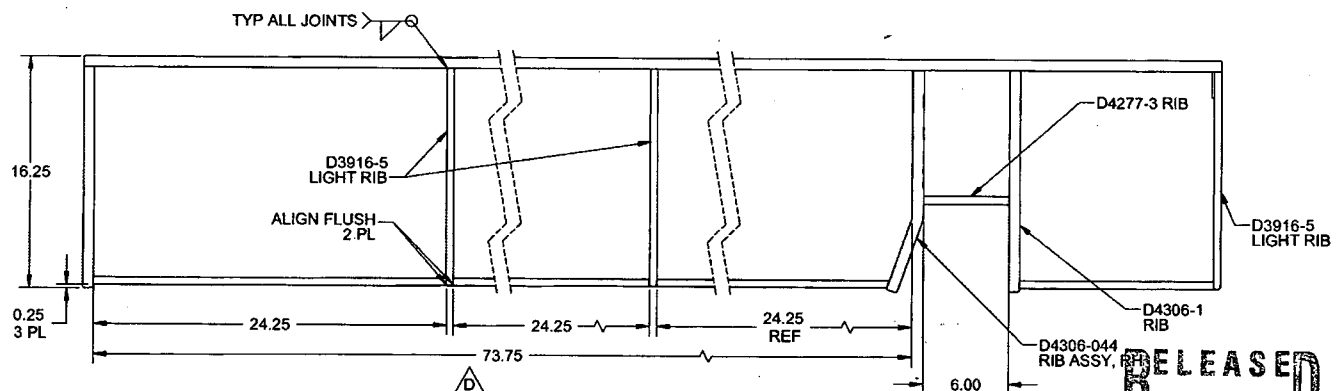
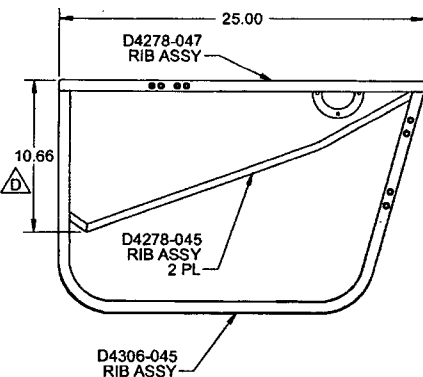
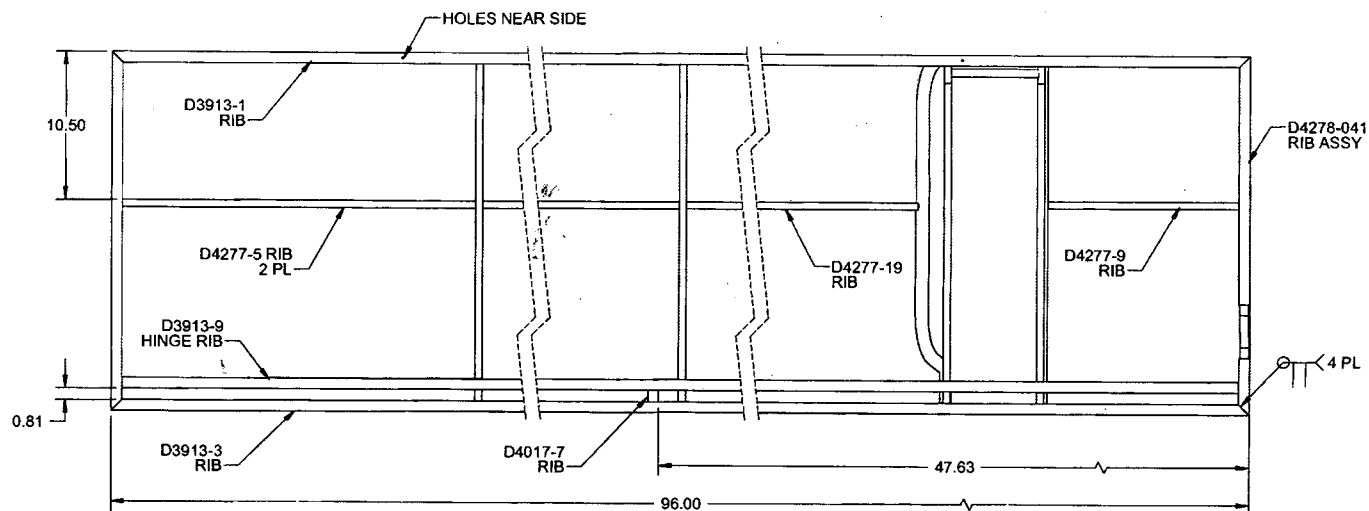


D4273-142 BASKET FRAME ASSY, RH

RELEASED
2011-02-24
M

DESIGN	JPH	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	SC		
CHECKED	AS	DRAWING NO.	REV. D
MFG. APPR.	AS	D4273	SHEET 9 OF 10
APPROVED	MM	TITLE	SCALE
DE APPR.	MM	BASKET BASE ASSY	NTS
DATE	11.02.09	COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

82647



D4273-142 BASKET FRAME ASSY, RH

RELEASED
R 2011-02-24

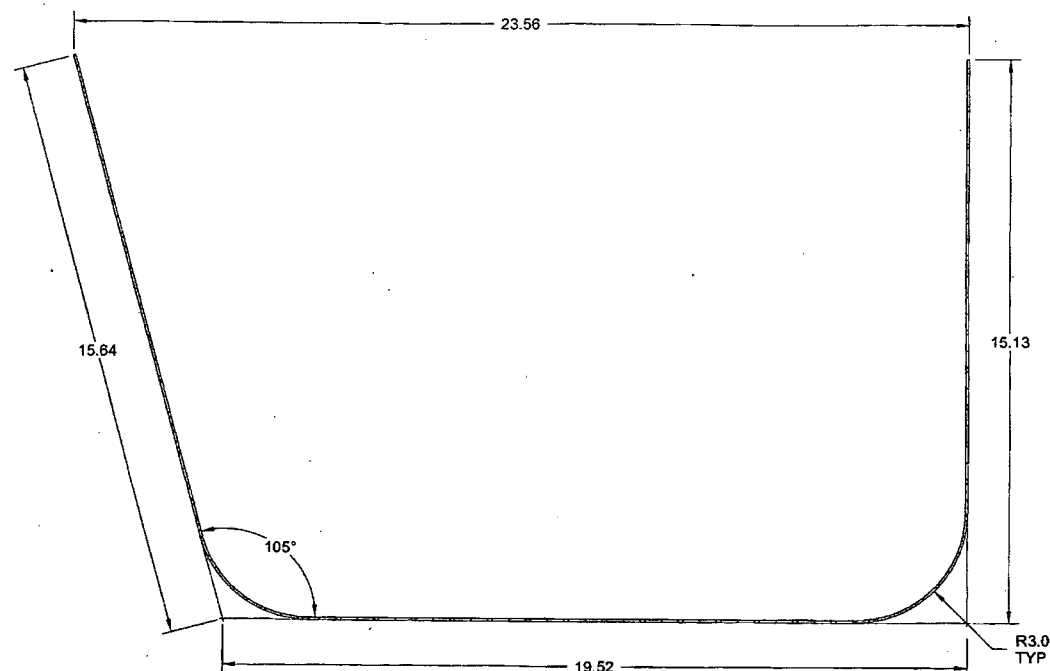
NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 EXCEPT FOR XX.XX DIMS: ± 0.06
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 24.77 lbs
- 8) WELD PER DART QSI 004

DESIGN	JPH	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	SC		
CHECKED		DRAWING NO.	REV. D
MFG. APPR.		D4273	SHEET 10 OF 10
APPROVED		TITLE	SCALE
DE APPR.		BASKET BASE ASSY	NTS
DATE	11.02.09	COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

SHOP COPY
 RETURN TO
 ENGINEERING
 UNCONTROLLED COPY
 SUBJECT TO AMENDMENT
 WITHOUT NOTICE
 WORK ORDER
 NO. 02647 MLJ
 12/04/04

RELEASED
 2010-12-06

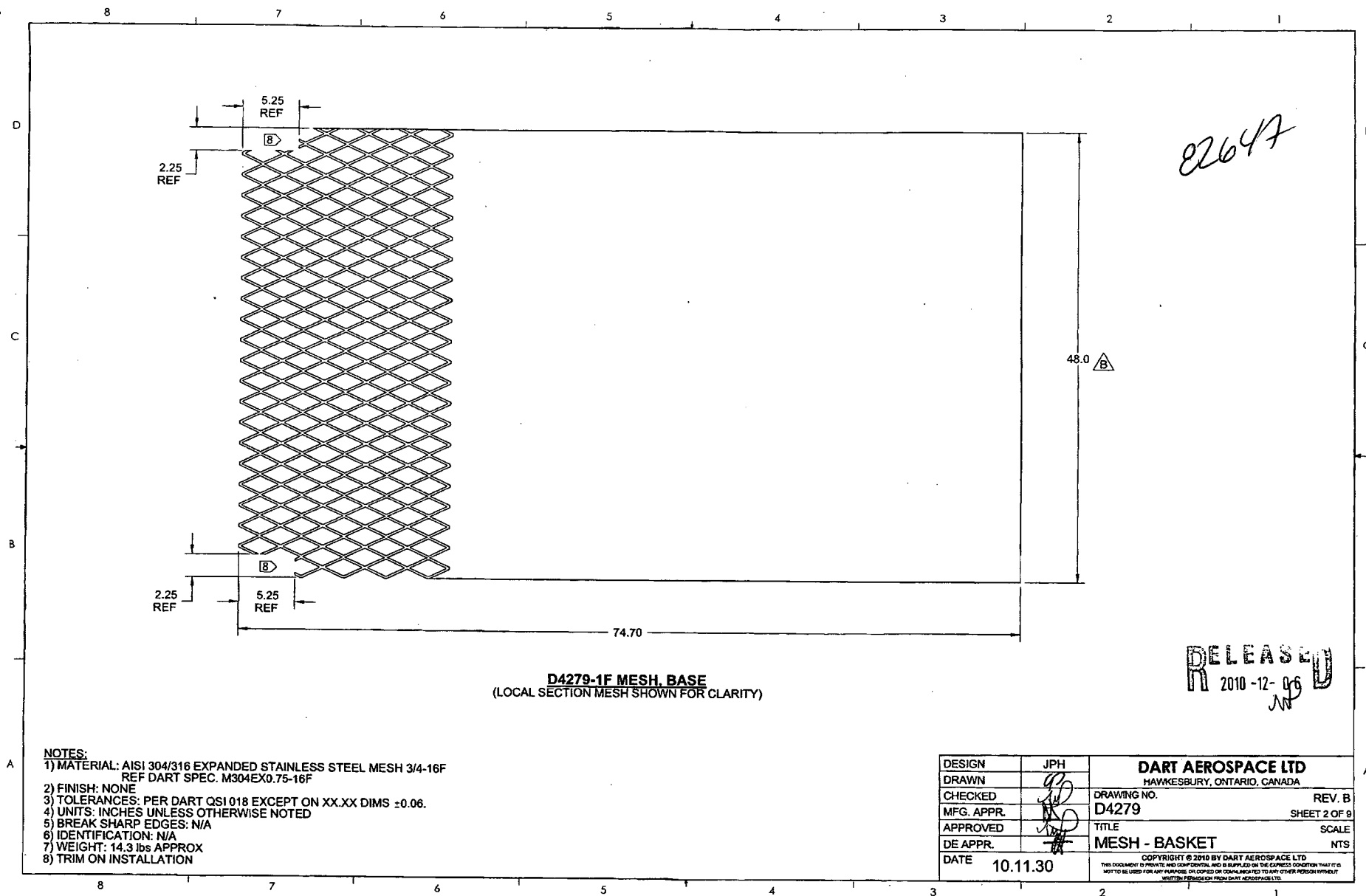


D4279-1 MESH - BASE

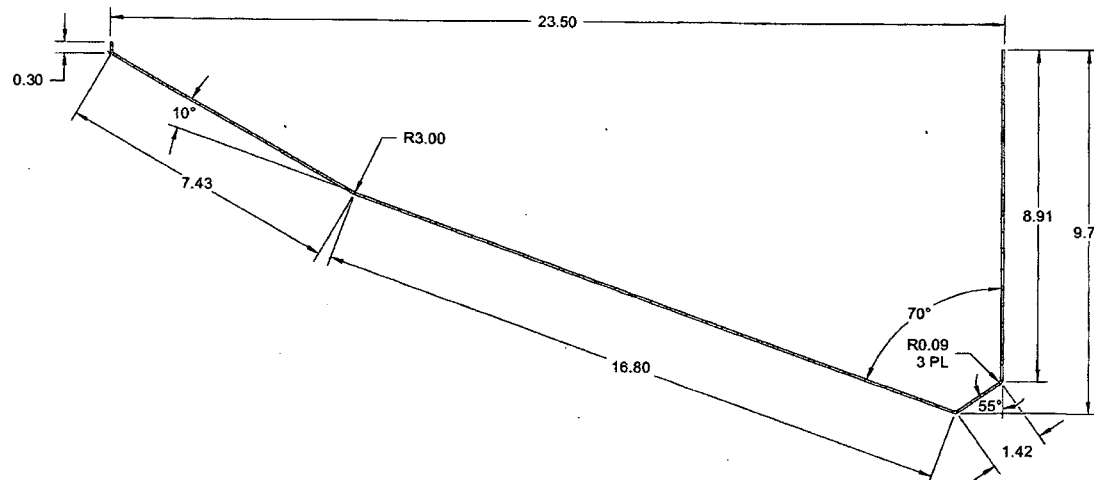
NOTES:

- 1) MATERIAL: MAKE FROM D4279-1F
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: SEE D4279-1F
- 8) PRE-FORMING OF MESH PER SHOP OPTION, THIS VIEW MAY BE USED FOR REF ONLY.

B	-3F: 6.50 WAS 20.90 (B5-4); REDESIGN -9 (SHT 7); ADD -11/-11F (SHT 8/9), 48.0 WAS 50.50 (C2-2, C7-9), CUTOUTS ON -9 NOW TRIMMED ON INSTALL (A6-6)	CP	10.11.30
A	NEW ISSUE	SC	10.11.25
REV.	DESCRIPTION	BY	DATE
DESIGN	JPH	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	JPH		
CHECKED	JPH	DRAWING NO.	REV. B
MFG. APPR.	JPH	D4279	SHEET 1 OF 9
APPROVED	JPH	TITLE	SCALE
DE APPR.	JPH	MESH - BASKET	NTS
DATE	10.11.30	COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR REPRODUCED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	



8264A



D4279-3 MESH-CHAMFER

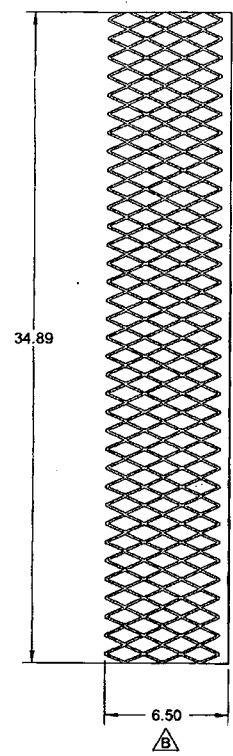
RELEASED
2010-12-06

NOTES:

- 1) MATERIAL: MAKE FROM D4279-3F
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 EXCEPT ON XX.XX DIMS ± 0.06 .
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: SEE D4279-3F
- 8) PRE-FORMING OF MESH PER SHOP OPTION, THIS VIEW MAY BE USED FOR REF ONLY.

DESIGN	JPH	DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. B
MFG. APPR.		D4279	SHEET 3 OF 9
APPROVED		TITLE	SCALE
DE APPR.		MESH - BASKET	NTS
DATE	10.11.30	<small>COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR REPRODUCED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

8264A



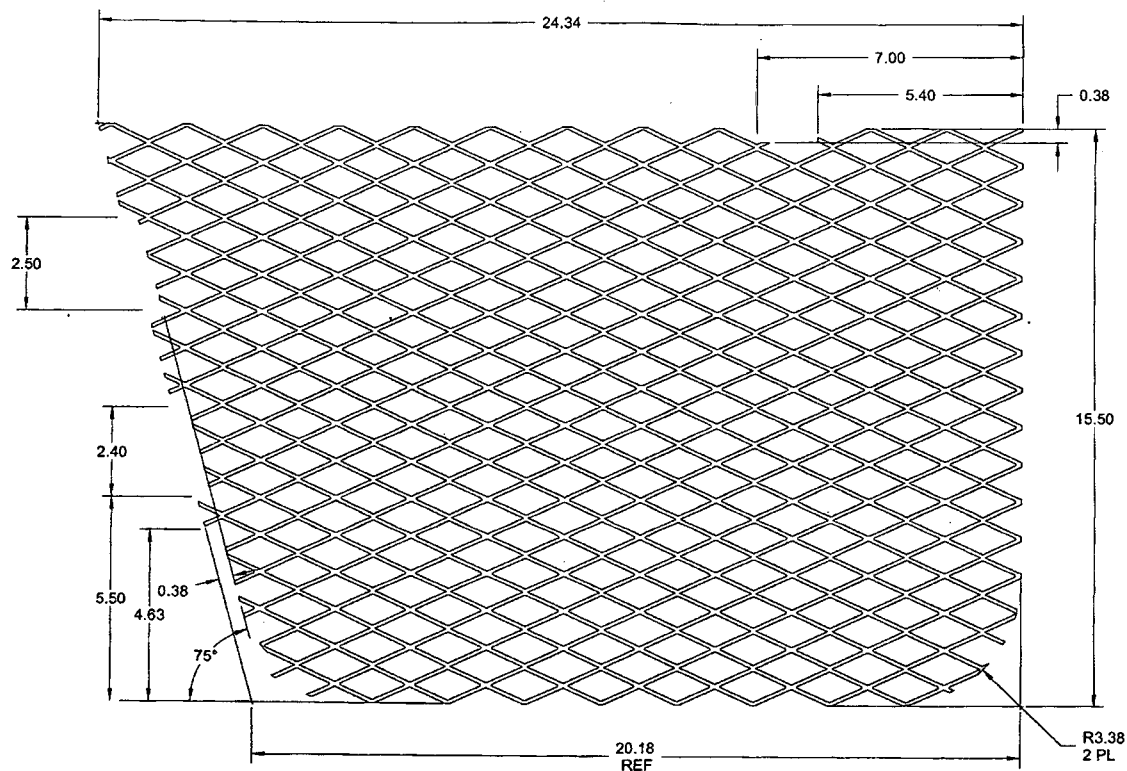
D4279-3F MESH-CHAMFER
(LOCAL SECTION MESH SHOWN FOR CLARITY)

RELEASE
2010-12-06
WNT

NOTES:

- 1) MATERIAL: AISI 304/316 EXPANDED STAINLESS STEEL MESH 3/4-16F
REF DART SPEC. M304EX0.75-16F
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 EXCEPT ON XX.XX DIMS ± 0.06 .
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.9 lbs APPROX
- 8) TRIM ON INSTALLATION

DESIGN	JPH	DART AEROSPACE LTD	
DRAWN	JPH	HAWKESBURY, ONTARIO, CANADA	
CHECKED	JPH	DRAWING NO.	REV. B
MFG. APPR.	JPH	D4279	SHEET 4 OF 9
APPROVED	JPH	TITLE	SCALE
DE APPR.	JPH	MESH - BASKET	NTS
DATE	10.11.30	<small>COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	



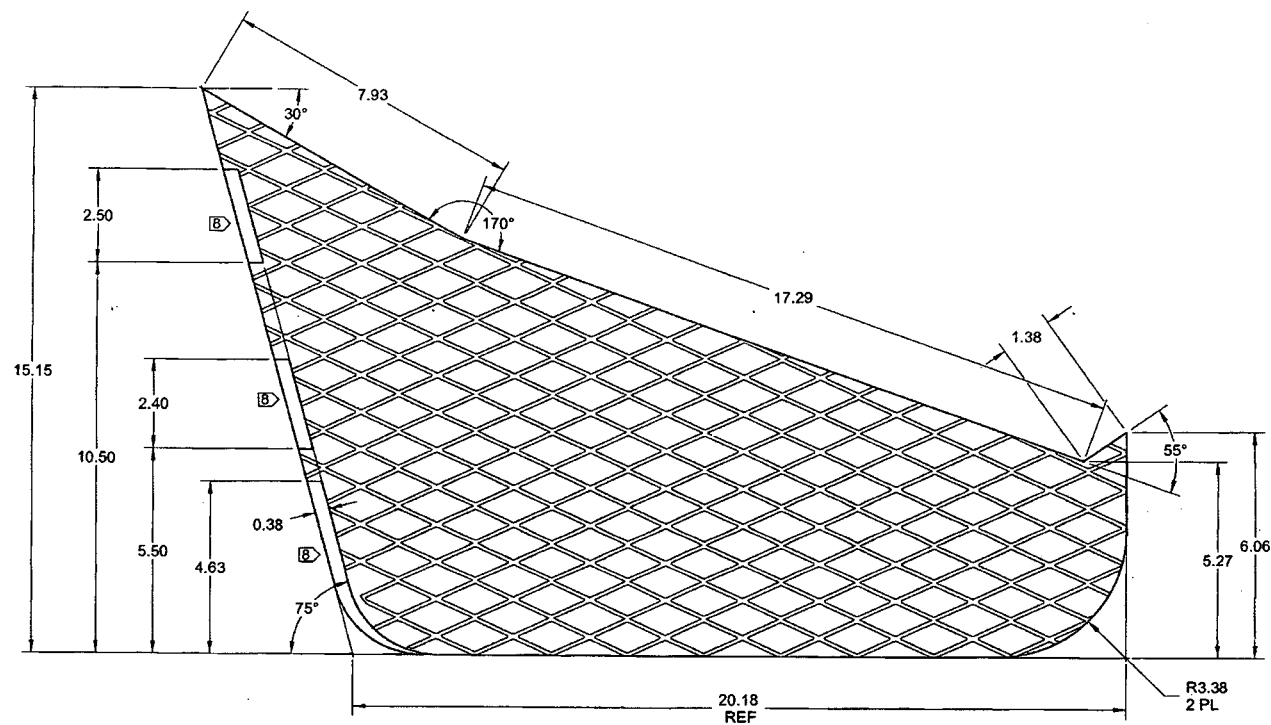
D4279-5 END MESH, BASKET

NOTES:

- 1) MATERIAL: AISI 304/316 EXPANDED STAINLESS STEEL MESH 3/4-16F
REF DART SPEC. M304EX0.75-16F
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 EXCEPT ON XX.XX DIMS ± 0.06 .
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 1.24 lbs

DESIGN	JPH	DART AEROSPACE LTD	
DRAWN	JPH	HAWKESBURY, ONTARIO, CANADA	
CHECKED	JPH	DRAWING NO.	REV. B
MFG. APPR.	JPH	D4279	SHEET 5 OF 9
APPROVED	JPH	TITLE	SCALE
DE APPR.	JPH	MESH - BASKET	NTS
DATE	10.11.30	COPYRIGHT © 2010 BY DART AEROSPACE LTD	
THIS DOCUMENT IS PRIVATE AND NOT BE LOANED, REPRODUCED OR COPIED IN ANY MANNER WITHOUT THE WRITTEN PERMISSION OF DART AEROSPACE LTD. IT IS NOT TO BE USED FOR ANY PURPOSE OR COMMUNICATED TO ANY OTHER PERSON WITHOUT			

2647



D4279-7 END MESH, BASKET

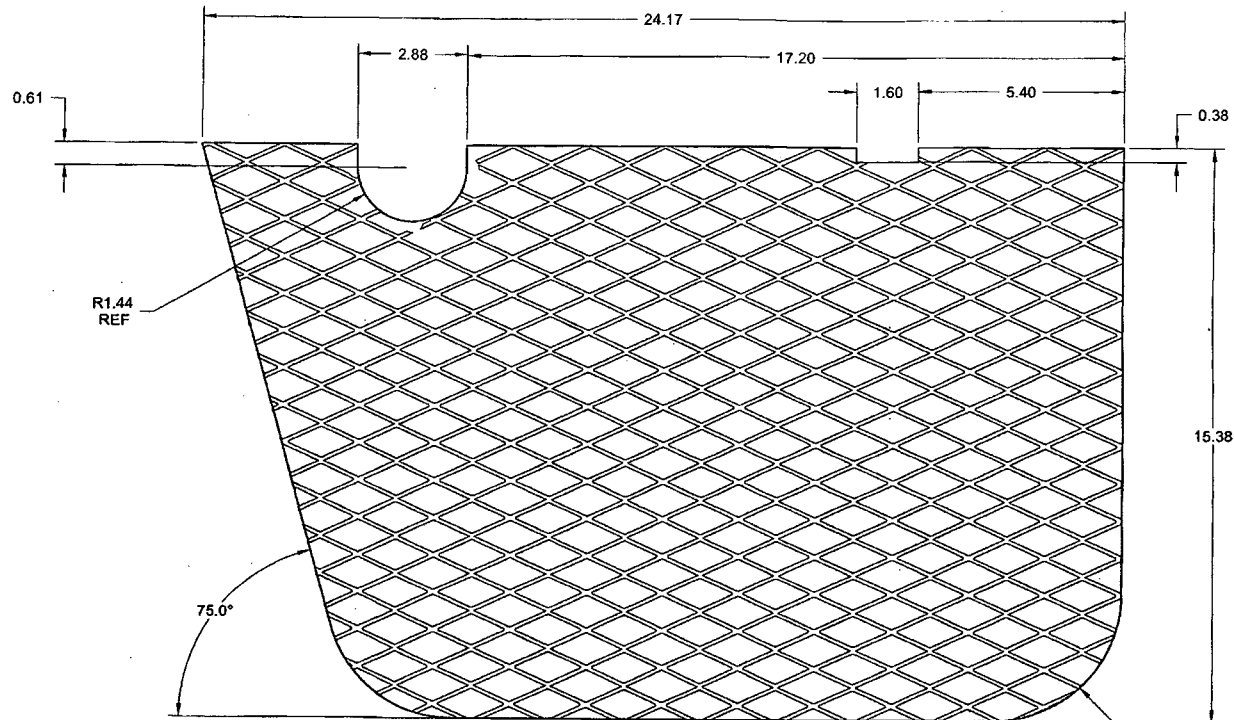
RELEASED
2010-12-06
AWB

NOTES:

- 1) MATERIAL: AISI 304/316 EXPANDED STAINLESS STEEL MESH 3/4-16F
REF DART SPEC. M304EX0.75-16F
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 EXCEPT ON XX.XX DIMS ± 0.06 .
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.71 lbs
- 8) TRIM ON INSTALLATION TO CLEAR HOLES (IF PRESENT)



DESIGN	JPH	DART AEROSPACE LTD	
DRAWN	JPH	HAWKESBURY, ONTARIO, CANADA	
CHECKED	JPH	DRAWING NO. D4279	REV. B
MFG. APPR.	JPH	SHEET 6 OF 9	
APPROVED	JPH	TITLE	SCALE
DE APPR.	JPH	MESH - BASKET	NTS
DATE	10.11.30	<small>COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	








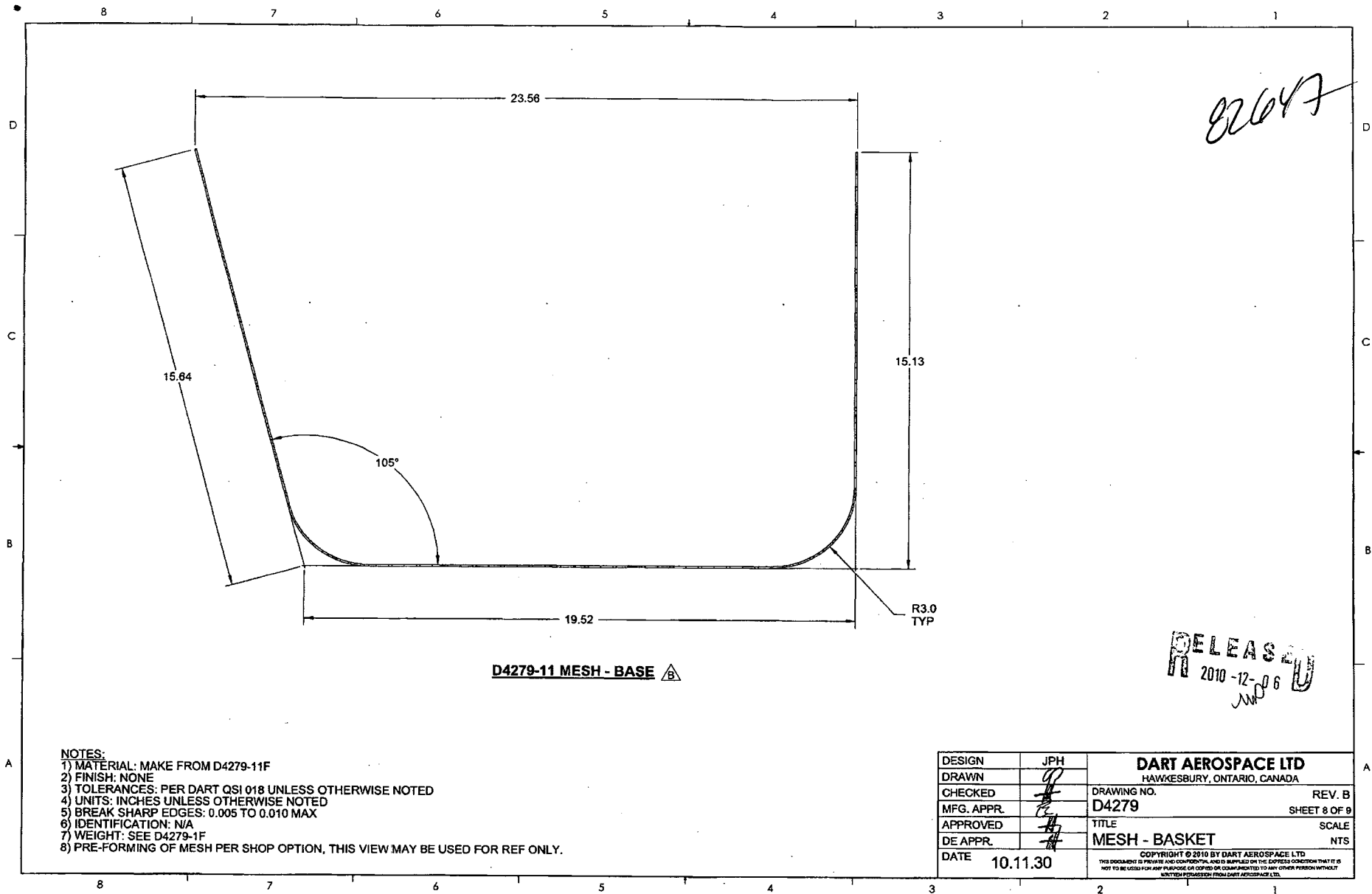
D4279-9 END MESH, BASKET

RELEASED
2010-12-06
WMD

NOTES:

- 1) MATERIAL: AISI 304/316 EXPANDED STAINLESS STEEL MESH 3/4-16F
REF DART SPEC. M304EX0.75-16F
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 EXCEPT ON XX.XX DIMS ± 0.06 .
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 1.22 lbs

DESIGN	JPH	DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. B
MFG. APPR.		D4279	SHEET 7 OF 9
APPROVED		TITLE	SCALE
DE APPR.		MESH - BASKET	NTS
DATE	10.11.30	COPYRIGHT © 2010 BY DART AEROSPACE LTD	
THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.			

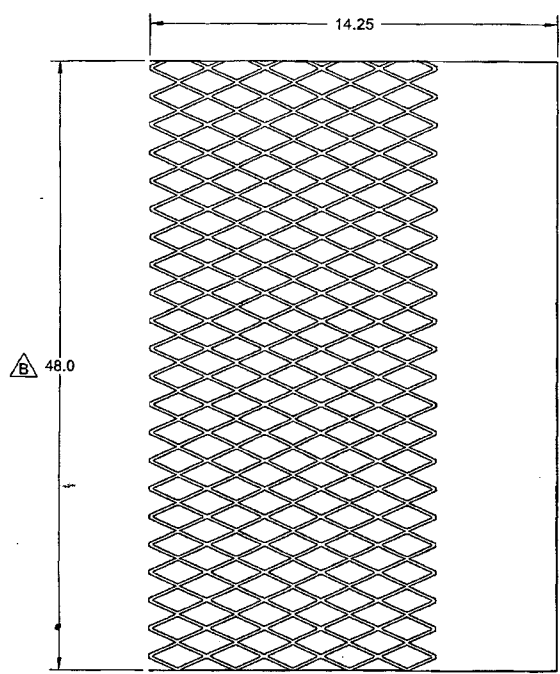


NOTES:

- 1) MATERIAL: MAKE FROM D4279-11F
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: SEE D4279-1F
- 8) PRE-FORMING OF MESH PER SHOP OPTION, THIS VIEW MAY BE USED FOR REF ONLY.

DESIGN	JPH	DART AEROSPACE LTD	
DRAWN	<i>[Signature]</i>	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. B
MFG. APPR.	<i>[Signature]</i>	D4279	SHEET 8 OF 9
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	MESH - BASKET	NTS
DATE	10.11.30	<small>COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL, AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR REPRODUCED IN ANY MANNER WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

02647



D4279-11F MESH, BASE
(LOCAL SECTION MESH SHOWN FOR CLARITY) B

RELEASED
2010-12-06
MD

- NOTES:**
- 1) MATERIAL: AISI 304/316 EXPANDED STAINLESS STEEL MESH 3/4-16F
REF DART SPEC. M304EX0.75-16F
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 EXCEPT ON XXXX DIMS ± 0.06 .
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: N/A
 - 6) IDENTIFICATION: N/A
 - 7) WEIGHT: 2.7 lbs APPROX
 - 8) TRIM ON INSTALLATION

DESIGN	JPH	DART AEROSPACE LTD	
DRAWN	<i>[Signature]</i>	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>[Signature]</i>	DRAWING NO. D4279	REV. B
MFG. APPR.	<i>[Signature]</i>	SHEET 9 OF 9	
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	MESH - BASKET	NTS
DATE	10.11.30	<small>COPYRIGHT © 2018 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSES OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

